

Work Order ID 60867

Monday, July 26, 2010 11:44:25 AM

Page 1

Item ID: D3191-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Backer Plate

Start Date: 7/26/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3191

Rev B

0.00

0.00

0.00

0.00

0.00

0.00

FLOW WATER JET

Memo

1-Cut as per Dwg D3191

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

QC8- Inspect parts - second check

Memo

10-7-09

10-7-09

8/10/08/03

FL

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

Powder Coating

START TIME: 12:50

OVEN TEMPERATURE: 320°

FINISH TIME: 1:20

160

QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

Setup Start

Stop

Run Start

Stop

46 0

6 BR 10-8-5

ml 10 08 05 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Required Date: 8/3/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 39

0.00

Packaging

Memo

0.00

Packaging

180

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/8/06

sf

(w)

10/08/09

ME

10-8-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 26, 2010 1:34:21 PM

Page 1

Work Order ID: 60867

Parent Item: D3191-1

Parent Item Name: Backer Plate



Start Date: 7/26/10

Required Date: 8/03/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-08-01 new issue DD verified by:EC
IPP ReV:B 09-01-28 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

116.2640

0.125

0.75



6061-T6 .063 Sheet



1810-739

Location

Loc Qty

Loc Code

MAT21

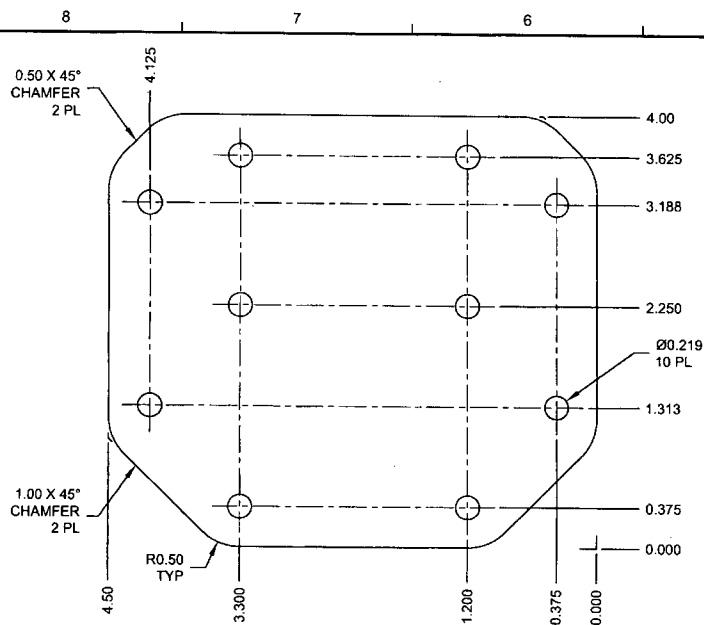
116.264

113608

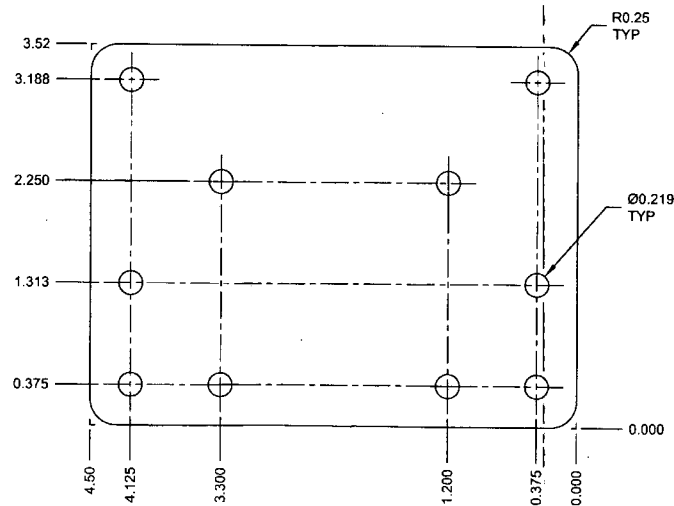
116.264

113608

6



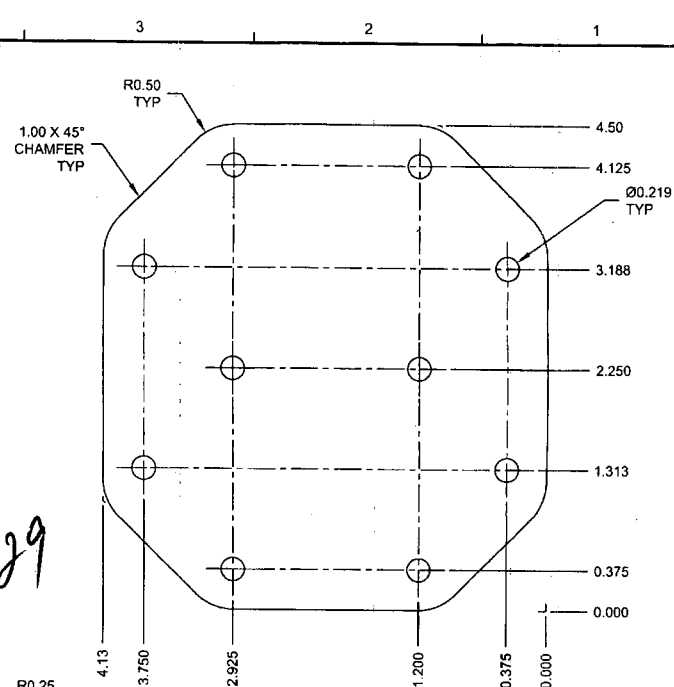
D3191-1 BACKER PLATE



D3191-5 BACKER PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66867

11/07/29



D3191-3 BACKER PLATE

RELEASED
09/07/15

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3191	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACKER PLATE	NTS
DATE	08.11.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	